

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019125**Date Inspected:** 21-Dec-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu tao**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, S.Chandrakumar was present during the times noted above for observations relative to the work being performed.

BAY#19

SMAW welding of repair weld is identified as 2G-043 of BK004B1-001 for BK004B-001. The welder is identified as 259566. ZPMC QC is identified as Mr. Xu tao. The welding variables recorded by QC are appeared to comply with the WPS-345-SMAW-2G-Repair and B-WR19178.

SMAW welding of repair weld is identified as 1G-044 of BK004A1-014 for BK004A-014. The welder is identified as 0259566. ZPMC QC is identified as Mr. Xu tao. The welding variables recorded by QC are appeared to comply with the WPS-345-SMAW-1G-Repair and B-WR19183.

SMAW welding of repair weld is identified as 2G-043 of BK004A1-013 for BK004A-013. The welder is identified as 0259566. ZPMC QC is identified as Mr. Xu tao. The welding variables recorded by QC are appeared to comply with the WPS-345-SMAW-2G-Repair and B-WR19209.

ABF QC MT personnel performing Re MT of after heat straightening area fillet welds is in progress of BK004A-013 and BK004B-001.

ZPMC personnel start their repair work of UT rejected welds in suspender bracket is identified as SB106E, SB106W and SB104E, SB104W.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Green tag issued for the following suspender bracket after NDT and VT carried out successfully.

SB	I stage	II stage
SB98E	012251	014949
SB98W	014941	014957
SB102W	014946	014959

This QA inspector performed MT 15% of weld areas previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated an MT report for this date. The members are identified as OBG Bike path. The weld designations reviewed as follows.

BK004A3-014-025,026
BK004A4-014-014,066
BK004A6-014-029,041,150,155
BK004A8-014-029,041,123,126

BK005A3-002-025,026
BK005A4-002-014,066
BK005A6-002-029,041,150,155
BK005A8-002-029,041,123,127

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant Conversation.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang-15--0042-2372, who represents the Office of Structural Materials for your project.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Inspected By:	Kumar, Chadra	Quality Assurance Inspector
----------------------	---------------	-----------------------------

Reviewed By:	Patel, Hiranch	QA Reviewer
---------------------	----------------	-------------